

Work Order ID 132567

132567

May-07-15 2:56:51 PM

Page 1

Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Prop Assembly 6.69"
 Start Date: 5/15/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/15/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-05-08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2332	Rev C1

100

0.00

100

Small Fab

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Debur.

8X

15/05/27
DAS 36 9-88

110

0.00

110

Brake NC

Brake NC

Memo

0.00

Punch and form D2332-11 to lenght as per dwg D2332 using DT8012
 (need 2 per ass'y)

8X

15/05/27
DAS 36 9-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 132567

132567

Page 2

Item ID: D2332-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lid Prop Assembly 6.69"

Stop

NS2

Start Date: 5/15/15 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/15/15 Req'd Qty: 8.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00

120

Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

8X

DAS
38
3-3-15
15/05/27

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

8

DAS
38
9-89

MAY 28 2015

140

0.00

140

Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: 11/123823

8

15-5-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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132567

Item ID: D2332-041

Accept

N900040100

Setup Stan

Revision ID:

Stop

Item Name: Lid Prop Assembly 6.69"

Start Date: 5/15/15

Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/15/15

Req'd Qty: 8.00

8

Customer:

Reference:

Run Stan

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00					
150			8x	DAS 43 9-89		MAY 28 2015	
QC	Memo	0.00					
Quality Control							
160	QC5- Inspect part completeness to step on W/O	0.00					
160			8x	DAS 43 9-89		MAY 28 2015	
QC	Memo	0.00					
Quality Control							
170		0.00					
170			Tumbler-8x			Jm 15-5-28	
Small Fab	Memo	0.00					
Small Fab	1- Tumble		8x			15/06/01	DAS 36 9-89
	2- Assemble as per dwg D2332						

DQA: _____ Date: _____



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May-07-15 2:56:51 PM

Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>(8)</u>			DAS 38 9-89 JUN 01 2015
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST367</u> Memo	0.00 0.00				<u>8x</u>	DAS 28 9-89	JUN 01 2015	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>M3</u>		JUN 03 2015	

ME
15-6-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																					

Picklist Print

May-07-15 2:56:51 PM

Page 1

Work Order ID: 132567

132567

Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 5/15/15

Required Date: 5/15/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.250		Purchased	No			100	f	12.5500	0.1	0.842106			DAS 36 9-89
M304R 250									**			15/05/27	
304 SS Round bar .250													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT028				12.55					
				122682				12.55		0.842106			
M304TR1.000W.049		Purchased	No			100	f	105.4700	0.43	3.621053			DAS 36 9-89
M304TR1 000W 049									**			15/05/27	
304 RD Tube 1.00 x .049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA002				105.47					
				125250				65.47		3.621053			
				m130551				40					
M304TR0.500W.035		Purchased	No			110	f	63.6000	1.25	10.52632			DAS 36 9-89
M304TR0 500W 035									**			15/05/27	
304 RD Tube .500 x .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA002				63.6					
				125513				2					
				126922				3.5					
				m128084				11					
				m128495 - 2x				31		1.31579			
				m128833				0.07					
				m129188 - 14x				8		9.21053			
				m130292				0.5					
				m131717				7.53					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

132567

D2332-041

Start Date: 5/15/15

Required Date: 5/15/15

Start Qty: 8.00

Required Qty: 8.00

AN4-4A Purchased No

170 Each 396.0000 1 8

AN4-4A

BOLT

**

15/06/01 DAS 36 9-89

Location

Loc Qty

Loc Code

FP001

24

m125709

24

ST325A

372

m129390

372

MS21042L4

Purchased No

170 Each 2,297.000 1 8

MS21042L 4

Locknut

**

15/06/01 DAS 36 9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

224

m127813

224

ST260a

62

m130799

56

m131803

6

ST305

1969

m128300

8

m130388

16

m130922

97

m131618

12

m132123

1836

NAS1149D0416J

Purchased No

170 Each 4,886.000 3 24

NAS1149D0416J

WASHER

**

15/06/01 DAS 36 9-89

Location

Loc Qty

Loc Code

ST270

4886

m131511

4886

May-07-15 2:56:51 PM

Shop Packet Print

Page 2

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								